

I CLAIM:

1. A high-volume insert for an injection-molded toy figure, comprising:
a body portion configured to form an inner supporting structure for an appendage of the toy figure, the body portion configured to occupy at least 50% of a volume of an associated portion of the appendage; and
at least one engagement portion for engaging another portion of the toy figure.
2. The high-volume insert of claim 1, wherein the body portion is configured to occupy at least 60% of the volume of the associated portion of the appendage.
3. The high-volume insert of claim 1, wherein the body portion is configured to occupy at least 70% of the volume of the associated portion of the appendage.
4. The high-volume insert of claim 1, wherein a maximum diameter of the insert is configured to extend at least 70% across a diameter of the associated portion of the appendage.
5. The high-volume insert of claim 1, wherein a maximum diameter of the insert is configured to extend at least 75% across a diameter of the associated portion of the appendage.

6. The high-volume insert of claim 1, wherein the body portion is configured to at least partially conform to an outer surface of the appendage.

7. The high-volume insert of claim 6, wherein the body portion is substantially frustoconical in shape.

8. The high-volume insert of claim 1, wherein the body portion includes a plurality of stabilization pegs for stabilizing the insert within a mold.

9. The high-volume insert of claim 1, wherein the engagement portion is configured to form a pivotable connection with another portion of the toy figure.

10. The high-volume insert of claim 9, wherein the engagement portion includes a cylindrical boss.

11. The high-volume insert of claim 9, wherein the engagement portion includes a substantially planar tab, and wherein a cylindrical boss protrudes from the tab.

12. The high-volume insert of claim 11, wherein a portion of the tab has a convex surface for supporting the cylindrical boss.

13. The high-volume insert of claim 9, further comprising at least one reinforcement ridge for supporting the engagement portion.

14. The high-volume insert of claim 1, wherein the at least one engagement portion includes a first engagement portion for engaging a torso portion of the toy figure, and a second engagement portion for engaging a limb portion of the toy figure.

15. The high-volume insert of claim 14, wherein the first and second engagement portions each include a substantially semicircular edge configured to rotate smoothly within an outer covering of the toy figure.

16. A high-volume insert for a skeleton of an injection-molded toy figure, comprising:

a first body segment;

a second body segment detachably joined with the first body segment to form a substantially hollow body of the insert; and

at least one engagement portion for engaging another portion of the toy figure.

17. The high-volume insert of claim 16, wherein the body of the insert is configured to occupy at least 50% of a volume of an associated portion of the toy figure.

18. The high-volume insert of claim 16, wherein the body of the insert is configured to occupy at least 60% of a volume of an associated portion of the skeleton.

19. The high-volume insert of claim 16, wherein the body of the insert is configured to occupy at least 70% of a volume of an associated portion of the skeleton.

20. The high-volume insert of claim 16, wherein a maximum diameter of the body of the insert is configured to extend at least 70% across an associated diameter of a limb of the figure.

21. The high-volume insert of claim 16, wherein the at least one engagement portion includes a first engagement portion for engaging a torso portion of the toy figure, and a second engagement portion for engaging a limb portion of the toy figure.

22. The high-volume insert of claim 16, wherein each engagement portion is configured to form a pivotable connection with another component of the toy figure.

23. The high-volume insert of claim 22, wherein each engagement portion includes a substantially planar tab, and a cylindrical connector.

24. The high-volume insert of claim 16, wherein the first body segment includes at least one cylindrical, hollow dowel, and wherein the second body segment includes at least one cylindrical, hollow boss for slidably receiving the dowel to join the body segments.

25. An injection-molded toy figure, comprising:
a torso and limbs made of at least one soft flesh-like outer layer molded over an inner skeleton, the inner skeleton including at least one high-volume insert disposed within a limb of the figure, the high-volume insert including:

a body portion configured to occupy at least 50% of a volume of an associated portion of the limb; and

at least one engagement portion for engaging another portion of the inner skeleton.

26. The toy figure of claim 25, wherein the body portion of the insert is configured to occupy at least 60% of the volume of the associated portion of the limb.

27. The toy figure of claim 25, wherein the body portion of the insert is configured to occupy at least 70% of the volume of the associated portion of the limb.

28. The toy figure of claim 25, the body portion having a maximum diameter configured to extend at least 60% across a diameter of an association portion of the limb.

29. The toy figure of claim 28, wherein the maximum diameter is configured to extend at least 75% across the diameter of the associated portion of the limb.

30. The toy figure of claim 25, wherein the at least one engagement portion includes a cylindrical boss for forming a pivotable connection with another portion of the inner skeleton.

31. A high-volume insert for an injection-molded toy figure, comprising:
a body portion configured to form an inner supporting structure for an appendage of the toy figure, wherein a maximum diameter of the body portion is configured to extend at least 70% across a diameter of the associated portion of the appendage;
and at least one engagement portion for engaging another portion of the toy figure wherein the engagement portion is configured to form a pivotable connection with another portion of the toy figure.

32. The high-volume insert of claim 31, wherein the body portion is configured to occupy at least 50% of the volume of the associated portion of the appendage.

33. The high-volume insert of claim 31, wherein a maximum diameter of the body portion is configured to extend at least 75% across a diameter of the associated portion of the appendage.

34. The high-volume insert of claim 31, wherein the body portion is configured to at least partially conform to an outer surface of the appendage.

35. The high-volume insert of claim 34, wherein the body portion is substantially frustoconical in shape.

36. The high-volume insert of claim 31, wherein the engagement portion includes a cylindrical boss.

37. The high-volume insert of claim 31, wherein at least one engagement portion includes a first engagement portion for engaging a torso portion of the toy figure, and a second engagement portion for engaging a limb portion of the toy figure.

38. The high-volume insert of claim 37, wherein the first and second engagement portions each include a substantially semicircular edge configured to rotate smoothly within an outer covering of the toy figure.